Work	Order	ID	541	05
VVUIR	Muci	\mathbf{I}	341	vJ



Page 1 November 30, 2009 8:19:25 AM D2989-043 Accept Setup Start Item ID: **Revision ID:** D Stop Item Name: Basket Lid Assembly Start Qty: 1.00 **Cust Item ID: Start Date:** 30/11/2009 **Required Date: 07/12/2009** Req'd Qty: 1.00 **Customer:** Reference: Run Start Tooling: **Process Plan:** Date: Approvals: Stop Date: SPC (Y/N): Date: QC: Reject Reject Set Up/ Draw Draw Plan Accept Insp. Sequence ID/ Operation Stamp Code Qty Qty Number Work Center ID Description **Run Hours** Number Rev. **Draw Nbr Revision Nbr** Rev D D2989 0.00 100 SM 09/12/03 Large Fab 0.00 Large Fab Memo 1- assemble all ribs in DT9446 jig, weld as per dwg D2989 Large Fab

2- tack weld mesh on basket as per dwg D2989 using DT9446 jig

3- to locate hinges and shims use D2989-041, weld as per dwg D2989

A/R ER316 S.S. Rod Batch: M10 92 13

110

OC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

	rt Aerospace Ltd D: WORK ORDER CHA									
N/O:				WORK ORDE	R CHANGES				1	
DATE	STEP		٠	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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							N) .		,	
							S. S. S.			
Part No) <u>*</u>	<u> </u>	PAR #:	Fault Category:	NC	R. Vos	No DO	Δ.	Date:	<u> </u>

	Resolution:	solution:	Disposition	:	QA: N/C Clos	losed: Date:						
NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section	В	Verification	A	Approval QC inspector				
DATE	DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng					
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D

Required Date: 07/12/2009

Item ID:

D2989-043

Accept

Setup Start

Stop



Revision ID: Item Name:

Basket Lid Assembly

Start Date:

30/11/2009

Start Oty: 1.00

Rea'd Oty: 1.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Draw

Rev.

Start Run

Stop



Date:

SPC (Y/N):

Set Up/

Date:

Reject

·1 Oty

Insp.

Stamp

Reject

Number

Sequence ID/ Work Center ID

120



QC

Quality Control

Operation Description

OC6- Inspect dimensions to drawing

Memo

Run Hours 0.00

0.00

Accept

Oty

Plan

Code

THESS. WASH.
White Gloss(Ref:4.3.5.2) per QS1005 4.3-Steel

Bf 09-12-9

0.00

130

Powdercoat

Powder Coating

m 112148 Memo

0.00

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per OSI 005 4.3 & Dwg D2989

IST COAT

START TIME:

OVEN TEMPERATURE

FINISH TIME:

2ND COAT:

START TIME: OVEN TEMPERATURE

FINISH TIME:

... Bl 09-12-9

W/O:	<u> </u>		W	ORK ORDER CHA	NGES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		olution:								
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DATE	STEP	Description of NC	Corrective Action Section B				Verific	ation	tion Approval	Approval
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Work Order ID 54105



Page 3

November 30, 2009 8:19:25 AM

Required Date: 07/12/2009

Item ID:

D2989-043

Accept

Setup Start

Stop



Revision ID:

D Basket Lid Assembly Item Mame:

Stars Tate:

30/11/2009

Start Oty: 1.00

Rea'd Otv: 1.00



Date:

Cust Item ID:

Customer:



Reference:

Approvals:

Process Plan: Date:

Tooling:

0.00

0.00

0.00

SPC (Y/N):

Date:

Run

Start

Stop



Sequence ID/ Work Center ID

140

OC

Operation Description

OC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

Draw Number Draw Rev.

Plan Code

Accept Qty

Reject Oty

Reject Insp. Number Stamp

MD 09/12/14

Date:

Quality Control

150

Packaging Packaging

Identify as per dwg & Stock Location:

Memo

Memo

0.00

160

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

									•	
W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	ì									**
Part No	:	PAR #:	Fault Cate	gory:	_ NCR	l: Yes N	10 DQ /	A:	Date:	
	R	esolution:	Dispositio	n:	_ QA:	N/C Clo	sed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE	(NCR)				
DATE	STEP	Description of NC	Corrective Action Sec			<u> </u>	Verific	cation	Approval	Approval
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Picklist Print

November 30, 2009 8:19:35 AM

Work Order ID: 54105

Parent Item:

Comments:

D2989-043RevD

Parent Item Name: Basket Lid Assembly



Start Date: 30/11/2009

Required Date: 07/12/2009

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments.											•	
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary. Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-1RevH	KARIA NIKA IKANI IKANI	Manufactured	No	· · ·		100	Each	20.0000	1.0000	,		
/				Wareho	<u>use</u>	Loc	<u>Oty</u>	Loc Code	1			
				Loc	ation							
				Main W	arehouse				i			
				ST			1		_		-	
					48101		1		i -		_	
				Main W	arehouse				1			
				WA			19				- 011	1 _
					53213		7		-	11/	Sy 091	12 03
					53662	100	12	2 0000			-	•
D2989-3RevD		Manufactured	No			100	Each	3.0000	1.0000			
Rib				Wareho	<u>ouse</u>	Loc	<u>Oty</u>	Loc Code				
•	•			Loc	<u>ation</u>				:			
				Main W	arehouse							
				ST			3		_		- 01/ 1	,
					53133		1			_ X	- SY 091	12/03
					53551		2		_		_	

W/O:			14/0	RK ORDER CHANG	050			 .		
DATE	STEP	PRO	OCEDURE CHAI		GES	Ву	Date	Qty	Approval Chief Eng /	Approval QC Inspector
		1							Prod Mgr	
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									4,	
Part No		PAR #:								
	Re	esolution:	Disposition):	QA	N/C CI	osed:		Date:	
NCR:			WORK ORDE	R NON-CONFORM	IANCE	(NCR)			····
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Sec Action Description Chief Eng	ection B Sign & Date		Verification Section C		Approval Chief Eng	Approval QC Inspector
			One Ling	Ciliei Eng	**	Date				
	77									
-						:				

Work Order ID: 54105

Parent Item:

D2989-043RevD

Parent Item Name: Basket Lid Assembly





Start Date: 30/11/2009

Required Date: 07/12/2009

Start Oty: 1 00

Required Oty: 1.00

Component from ID/ Replacement Mfg/ Bin Primary Last Route Unit of Qty on Remaining Item Name Item ID Purch Item Location Location Seq ID Measure Hand Qty To Pice	S Sta
D2989-4RevD Manufactured No 100 Each 3.0000 1.0000	
Warehouse Loc Qty Loc Code	
<u>Location</u>	
Main Warehouse	4 (
ST 3	1x M 09/12/0
53132 1 53552 2	1x 300 01 10 10
53552 2 1 D2989-5RevD Manufactured No 100 Each 4.0000 2.0000	
Warehouse Loc Oty Loc Code	
<u>Location</u>	
Main Warehouse	
ST 4	
53553 4	-2x Sg 09/18

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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		· · ·											
Part No	•	PAR #:	Fault Cate	gory:	NCF	R: Yes I	No DQA	\:	Date:				
		esolution:											
NCR:			WORK ORD	ER NON-CONFORM	IANCE	(NCR				· · · · · · · · · · · · · · · · · · ·			
		Description of NC		Corrective Action Se	Section B			-4:	Annuard				
DATE	STEP	Section A	Initial Action Descr Chief Eng Chief Eng		ion Sign & Date		Verification Section C		Approval Chief Eng	Approval QC Inspector			
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Work Order ID: 54105

Parent Item:

Comments:

D2989-043RevD

Parent Item Name: Basket Lid Assembly



Start Date: 30/11/2009

Required Date: 07/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Replacemen Item Name Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3182-1RevA	Manufactured	No			100	Each	16.0000	2.0000			
	1										

Hinge

Warehouse	Loc Qty	<u>L</u>	oc Code
Location			
Main Warehouse			
ST	2		
51253	2		
Main Warehouse			
WA	14		
53445	14		+
	100 E	ach	12.0000 2

2 St 09/12/03

D3442-3RevA

Manufactured



Shim

Loc Qty Loc Code Warehouse Location Main Warehouse ST 12 42718 11 53137

2x St 09/12/03

Dart	Aer	os	pace	Ltd
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W/O:	WORK ORDER CHANGES											
DATE	STEP	PRO		OCEDURE CHANGE By				Date Qty Approve Chief Eng Prod Mgi				
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Part No		PAR #:										
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NCR:				ER NON-CONF								
DATE STED Description of N		Description of NC	Corrective Action Section B			· · · · · · · · · · · · · · · · · · ·	Verific	ation Approva	Approval	Approval		
DAIL	DATE STEP	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign & Date	& Section C		Chief Eng	QC Inspector		
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										2		
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Work Order ID: 54105

Parent Item:

D2989-043RevD

Parent Item Name: Basket Lid Assembly

Comments:



Start Date: 30/11/2009

Required Date: 07/12/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:		,							tart Qty. 1.00		recquired Qty	. 1.00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3827-041RevA		Manufactured	No			100	Each	12.0000	1.0000			
						,						
Rib Assembly (Inboard)		i							-			
		i		<u>Wareho</u>	<u>use</u>	Loc	<u>Qty</u>	Loc Code	ŧ			
V		1	٠.	Loca	<u>ation</u>				1		, .*	
		1		Main Wa	arehouse				!	f	. A	•
				ST			12		_		· lU	1. 1 -
					53661		6		·	_X	201 09	112/03
		1			53901		6	• • • • •			-	
D3832-5RevA	#118115 1915 IIJ BHFFII IBI IBBI	Manufactured	No			100	Each	2.0000	1.0000			
		•										
Mesh (Lid)									1			
				Wareho		<u>Loc</u>	<u>Otv</u>	Loc Code	1		<i>5</i> :	
•					<u>ation</u>		r		i,			
••		1			arehouse						4 1	
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		i			52049		2	,	_	12	U U	4 Malus
D3833-5RevA		Manufactured	No			100	Each	27.0000	2.0000		•	
Mesh (Lid End)		1							•			
				<u>Wareho</u>	<u>ouse</u>	Loc	: Qty	Loc Code				
V				Loc	ation							
		1		Main W	arehouse							
		1		ST			27		-		- Ost -	7/12/03
		1			51305		6		_	46	SI) O	7 12 03
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		1										

W/O:		// · · · · · · · · · · · · · · · · · ·	WC	RK ORDER CHANG	iES				
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			• 1			¥ .			
						•			
Part No	:	PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQ	A:	Date:	·
Resolution: Disposition:				1:	_ QA: N/C (Closed:		Date:	
NCR:				R NON-CONFORM					
5.475		Description of NC Corrective Action			V			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti	cation on C	Chief Eng	QC Inspector
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Work Order ID: 54105

Parent Item:

D2989-043RevD

Parent Item Name: Basket Lid Assembly

Comments:



Start Date: 30/11/2009

Required Date: 07/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Furch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3838-041RevA		Manufactured	No			100	Each	3.0000	1.0000			

Rib Assembly (Basket Lid, LH)

Warehouse	<u>Loc</u>	Loc Oty	
<u>Location</u>			
Main Warehouse			
ST		3	
53134		1	,
. 53550		2	
	100	Fach	3 0000

D3838-042RevA

Manufactured

1.0000

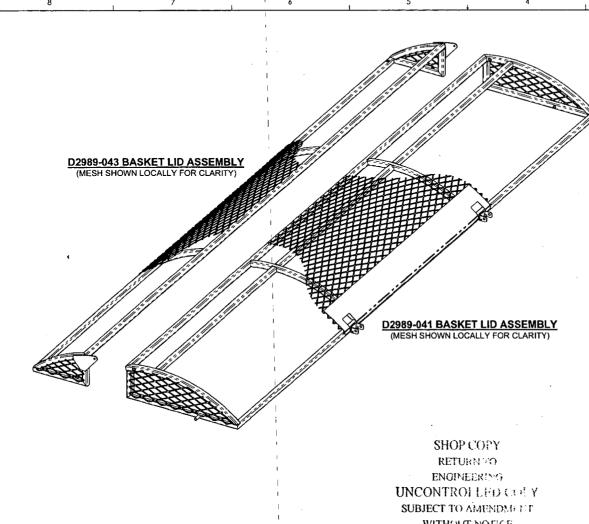
Rib Assembly (Basket Lid, RH)



Warehouse	Loc Qty	Loc Code
Location		i
Main Warehouse		
ST	3	
53135	1	
53549	2.	

Dart Aerospace	Ltd
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		V	VORK ORDER CHANG	ES					
STEP	PRO	OCEDURE CH	IANGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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:	PAR #:	Fault Ca	tegory:	_ NCR: Ye	s N	o DQ A	۸:	_ Date: _	
Re	esolution:	Disposit	ion:	_ QA: N/C	Clos	sed:		Date: _	
		WORK OR	DER NON-CONFORMA	ANCE (N	CR)				
STED	Description of NC		Corrective Action Section B			Verific	ation	Approval	Approval
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	Х		D2989-041	BASKET LID ASSEMBLY
2		Х	D2989-043	BASKET LID ASSEMBLY
			50500	LADEL DI ATE
3	1		D2506	LABEL PLATE
. 4	1_		D2512-7	RIB
- 5	2		D2581	MOUNTING BRACKET
6		_1_	D2989-3	RIB
17		1	D2989-4	RIB
- 8		2	D2989-5	RIB
. 9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
.13		2	D3442-3	SHIM
.14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
.16		. 1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
119	1	<u> </u>	D3836-041	RIB ASSY (BASKET LID, LH)
.20	1		D3836-042	RIB ASSY (BASKET LID, RH)
:21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
:23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

REVISED -041/-043 PARTS LISTS AND ADDED "ITEM"
COLUMN TO PARTS LIST (ZN D3-1): D3836-041 REPLACES
D2899-01-51: D3836-042 REPLACES D2989-10:15: D3839-041
REPLACES D2989-11-7: D3838-042 REPLACES D2989-2/-7:
D3852-041 REPLACES D2989-11: D3852-042 REPLACES
D2899-2; REMOVED D2327-3 (NOW INSTALLED ON D3836
DWG), D2989-141 (NOW ON D3836 DWG), D2989-11/227-145
(NOW ON D3838 DWG) AND D2989-11/12 (NOW ON D3852
DWG)
REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM 08.09.24 FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERED TO "B" FORMAT AND CURRENT DRAFTING STANDARD 08.06.20 ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS PH 05.06.07 NEW ISSUE DS 00.10.27 REV. DATE DESCRIPTION BY

JESIGN	u	J DARI AEROSPACE LID				
DRAWN	7	HAWKESBURY, ONTARIO, CAN				
CHECKED	ASS	DRAWING NO.	REV. D			
MFG. APPR.	MO	D2989	SHEET 1 OF 5			
APPROVED	100	TITLE	SCALE			
DE APPR.	-#	BASKET LID ASSEMBLY	NTS			
DATE 08.0	09.24	COPYRIGHT © 2000 BY DART AEROSPAI THE DOCUMENTS HEALTH AND CONTROL AND IS SUPPLIED ON THE DOWN AND THE INSTRUMENT HEALTH AND ADDRESS OF COMPANY HEALTH AND THE PROPERTY HEALT	ESS CONCITION THAT IT IS			

WITHOUT NOTICE

1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
8) WELD PER DART QSI 004

